

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024014**Date Inspected:** 28-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #19

This QA Inspector observed the following work in progress,

Flux Cored arc welding (FCAW)

Weld joint- 135, 136 Located on Cable Bracket SA6531-001. Welder is identified as 062749. ZPMC Quality Control Inspector (QC) is identified as Peng Wen Jan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint- 139 Located on Cable Bracket SA6531-001. Welder is identified as 062749. ZPMC Quality Control Inspector (QC) is identified as Peng Wen Jan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 046, 047 Located on Cable Bracket SA6529-001. Welder is identified as 062807. ZPMC Quality Control Inspector (QC) is identified as Peng Wen Jan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

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Weld joint- 131, 132, Located on Cable Bracket SA6029. Welder is identified as 062749. ZPMC Quality Control Inspector (QC) is identified as Peng Wen Jan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 099 Located on Cable Bracket SA6031-001. Welder is identified as 058792. ZPMC Quality Control Inspector (QC) is identified as Peng Wen Jan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as OBG Component, Cable Bracket SA6030-001. The component and weld designation identified as follows:

SA6030-001- 022

SA6030-001- 023

Blast Shop # 2

This QA inspector, Baskar Govindarajan, performed Post blast weld inspection of internal and external surfaces of East tower, Lift 6. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower. This inspection was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227, and Mr. Mike Hasler (B293) . All the marked points shown to ZPMC inspector Mr. Zhu Feng and ABF Inspector Mr. Chen. All the weld repair areas marked in weld map in detail and the same was signed by ZPMC and ABF Inspector.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint- 001/ 002, Located on Bike path Hand rails, FS2. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint- 003, Located on Bike path Hand rails, FS23. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
